

546

DART AEROSPACE LTD		Work Order:	24699
Description: Bracket Assembly		Part Number:	D3121-043
			D3121-044
Dwg: D3121 Rev. C2 page 1, 3, 5		Qty:	5 Kits
D3121-043 replaces Premier P/N B30-23000-37			
D3121-044 replaces Premier P/N B30-23000-38			
Page 1 of 1			

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	HA	05.10.26	5
2	MV	Cut (1) blank per D3121-13 & (1) blank per D3121-14 Cut blanks (1.00" x 2.00") x 3.250" Long Bar Material: 17-4 SS per AMS 5604/5643 (M17-4-B1.000x02.000) Batch: M14773	JL	05.11.14	10
3	MV	Machine D3121-13 as per Folio FA329 and Dwg D3121	BG	05.11.16	5
4	QC2	Inspect parts as they come off the CNC machine	BG	05.11.16	5
5	MV	Machine D3121-14 as per Folio FA329 and Dwg D3121	BG	05.11.16	5
6	QC2	Inspect parts as they come off the CNC machine	BG	05.11.16	5
7	MV	Deburr Break all sharp edges 0.005 to 0.015	BG	05.11.16	10
8	MV	Scribe batch number to D3121-13 & D3121-14 at the back face.	BG	05.11.16	10
9	QC5	Second check D3121-13 and D3121-14	SA	05.11.16	10
10	GA	Assemble D3121-043 as per Dwg D3121 Pick: Qty Part Number Description Batch 2 D3121-21 Bolt B 24475B 2 D3121-241 Bearing Assembly B 24777 Identify as D3121-043	BG	05.11.20	2
11	GA	Assemble D3121-044 as per Dwg D3121 Pick: Qty Part Number Description Batch 2 D3121-21 Bolt JL 5 24224 B 24475B 2 D3121-241 Bearing Assembly B 24777 Identify as D3121-044 12 (B 25057)	BG	05.11.20	10
12	QC5	Inspect work to Step 10 & 11	SB	05/12/21	10
13	ST	Identify and Stock in Spacedoor cell D3121-043 Qty 5 D3121-044 Qty 5	DL	05/12/21	10
14	AC	Parts to Stock and Prorate Cost to parts per Step 13 Cost / part:	SUC	06.01.03	10
15	DC	Close W/O Inspect Level 21	SD	06/01/03	10

405 547

Rev	Date	Change	Revised By	Approved
A	02.05.21	New issue	NG	
B	03.05.02	Reformat	KJ/RF	
C	05.01.27	Revised Steps 10-11	KJ/JLM	

RELEASED
05.01.27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	24699
Description: Bracket		Part Number:	D3121-13
Inspection Dwg: D3121	Rev: C2	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300	+/-0.010	.298	✓			
0.080	+/-0.010	.078	✓			
0.392	+0.002/-0.000	.392	✓			
0.350	+/-0.010	.352	✓			
1.540	+/-0.010	1.541	✓			
R0.250	+/-0.010	.250	✓			
1.800	+/-0.010	1.802	✓			
1.370	+/-0.010	NA				
1.050	+/-0.010	NA				
0.420	+/-0.010	NA				
0.400	+/-0.010	.397	✓			
1.220	+/-0.010	1.217	✓			
2.63	+/-0.030	2.630	✓			
2.80	+/-0.030	2.760	✓			
2.48	+/-0.030	2.460	✓			
0.130	+/-0.010	.133	✓			
0.300	+/-0.010	.300	✓			
0.080	+/-0.010	.078	✓			
0.260	+/-0.010	.262	✓			
0.032	+/-0.010	.032	✓			
0.200	+/-0.010	.204	✓			
0.400	+/-0.010	.398	✓			
0.381	+/-0.010	.373	✓			

Measured by: TBC	Audited by: SA	Prototype Approval:	N/A
Date: 05.11.15	Date: 05.11.15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue P/O D3121-043/-044	KJ/JLM	<i>[Signature]</i>

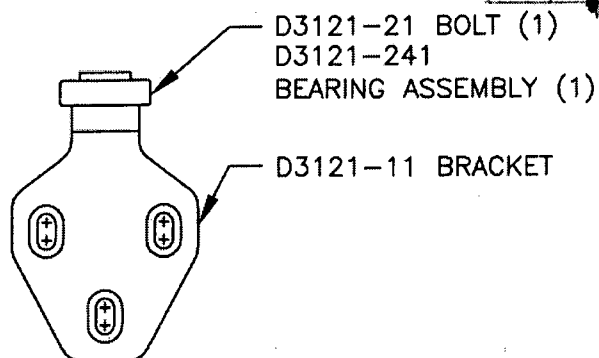
RELEASED

[Signature] 05.02.27



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 1 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
C1	CP# 04.03.26	3.97 WAS 4.00; 6.11 WAS 6.14	
C2	# 04.04.26	0.230 WAS 0.238	

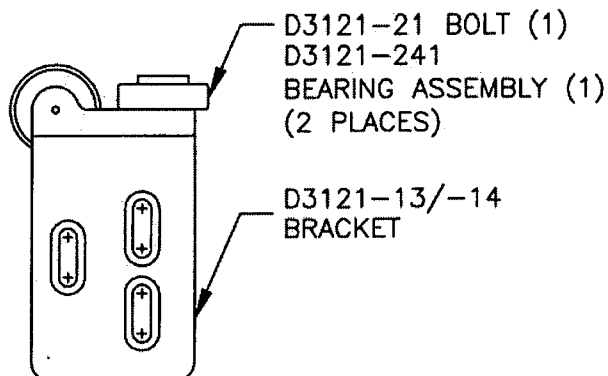
RELEASED
04-03-01 *[Signature]*



D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-11 BRACKET

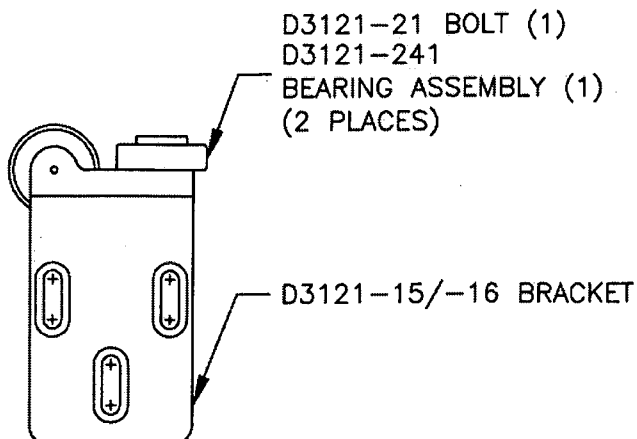
D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)
(2 PLACES)

D3121-13/-14
BRACKET

**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)
(2 PLACES)

D3121-15/-16 BRACKET

**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-35/-36)

COPY
IDENT
FIGURE OF
WORK ORDER
NO. 24699

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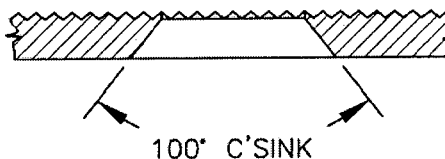
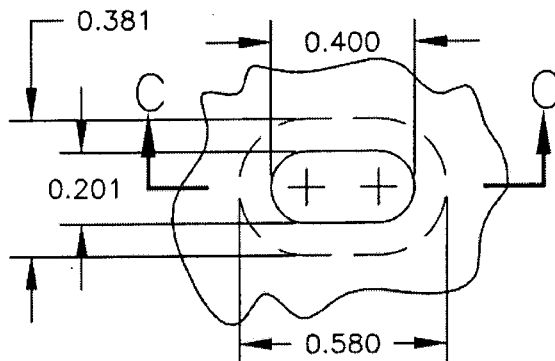
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DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 3 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

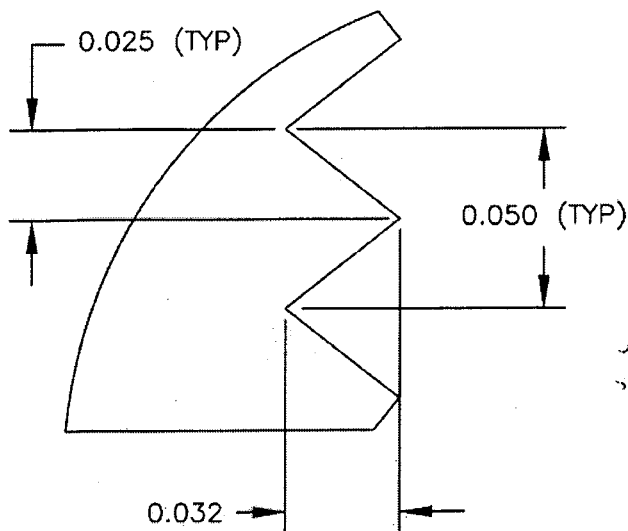
RELEASED
04.03.01

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20







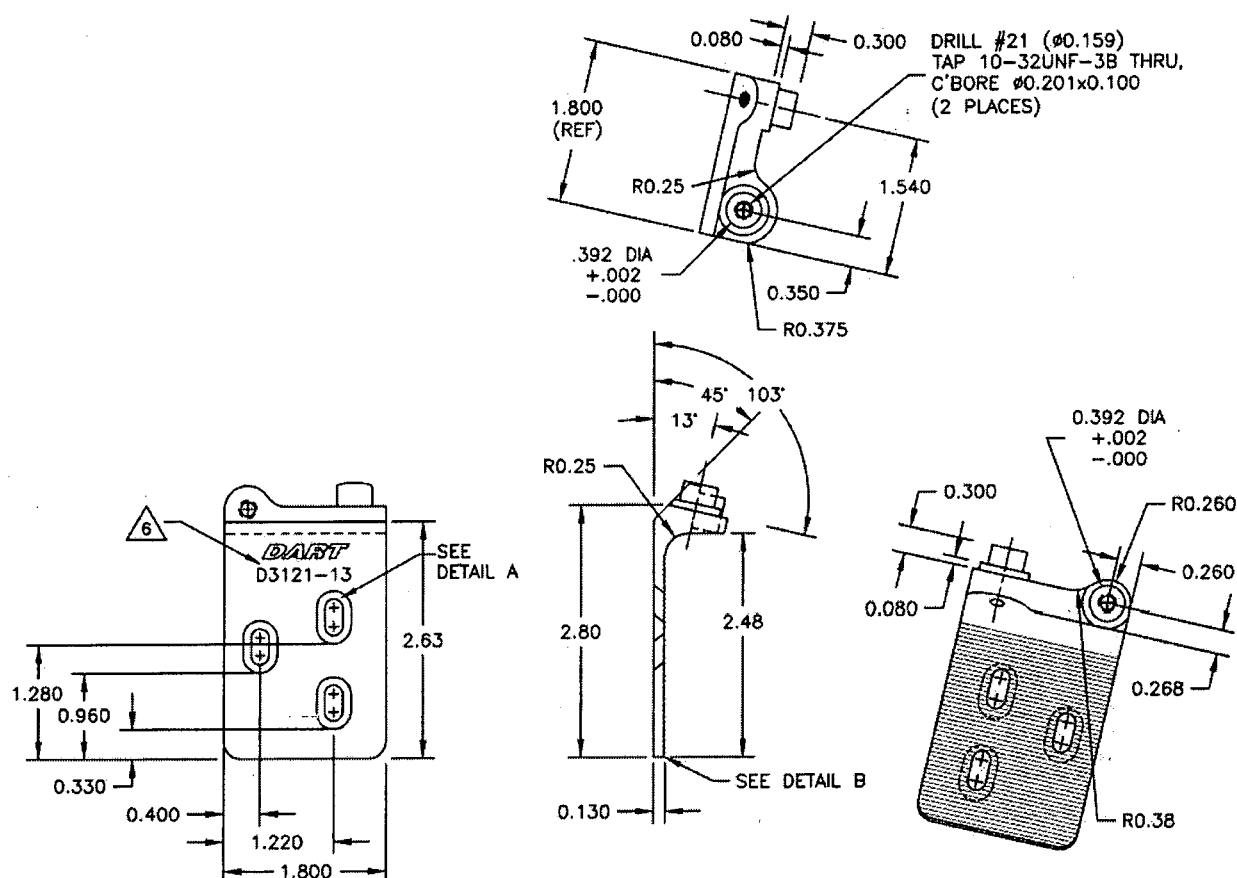
See drawing for
dimensions
and notes
without
work order
NO. 24699

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DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3121	REV. C SHEET 5 OF 10
DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

SHOP COPY
RETURN TO
ENGINEERING

SECRET

WORK OF

NO 24699

RELEASED
04-03-01

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 26, 2005
03:12 pm

Work Order No : 0024699
Project Name : D3121-043
Project For : WK546
Work Order Type : Main
Main WO Number :
House Part Number : D3121-043
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 10-26-05
Est Finish Date : 11-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code :
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Date: Friday, 11/18/2005 9:56:21 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 24699	
Estimate Number : 10701	
P.O. Number :	Part Number : D3121043
This Issue : 11/18/2005 S.O. No. :	Drawing Number : D3121 REV C2
Prsht Rev. : NC	Project Number :
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C2
Previous Run :	Material :
Written By :	Due Date : 12/12/2005 Qty: 5 Um: Each
Checked & Approved By :	
Comment : Est C 05.01.27 Revised Steps 10-11 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M174B1000X02000	17-4 SS Bar
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks: (1.000" x 2.000") 3.250" long		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3121-13 as per Folio FA329 and Dwg D3121 Identify as D3121-13 2-Deburr 3-Scribe batch number		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
6.0	D312121	Bolt
7.0	D3121241	Bearing Assembly

Date: Friday, 11/18/2005 9:56:22 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 24699

Part Number: D3121043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3121-13as per Dwg D3121.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:45 pm

Work Order No : 0024699
Project Name : D3121-043
Project For : WK546
Work Order Type : Main
Main WO Number :
House Part Number : D3121-043
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 10-26-05
Est Finish Date : 11-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00